



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5770-5

Job Sheet 208152



Part No: D5770-5

Job Qty: 12 pcs

Part Name: Hoop

POSITIVE RECALLEFFECTIVE 2012/12 AUTH SM

Part Weight: 0 lbs

Status: New

RELEASED _____ DATE _____ Priority: Medium

Job Created: 3/12/20

Job Tracking No:

Due Date: 3/23/20

Created By: Jennifer Renwick

Type: Stock

Description:

Note: URF 20-522 DWG 5770 REV.A IPP REV.A NEW ISSUE 20.01.14 JV VER:DD

Ship Via:



Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Run Hrs Hrs	Workcenter/Supplier	Lead Time	Sign-off
100	Large Fab - Welded Assy-1	12 pcs	3/23/20	3/23/20	0.00 4.00	Large Fab - 1		
						Large Fab - 10		
						Large Fab - 2		
						Large Fab - 3		
						Large Fab - 4		
						Large Fab - 5		
						Large Fab - 6		
						Large Fab - 7		
						Large Fab - 8		
						Large Fab - 9		
						Large Fab - 11 (Various)		NAFC
						Large Fab - 12		
110	QC 5	12 pcs	3/23/20	3/23/20	0.00 0.00	QC 5 - 10		
						QC 5 - 12		
						QC 5 - 17		
						QC 5 - 18		
						QC 5 - 19		
						QC 5 - 22		
						QC 5 - 24		
						QC 5 - 3		
						QC 5 - 43		
						QC 5 - 49		
						QC 5 - 51		
						QC 5 - 58		
						QC 5 - 68		
						QC 5 - 9		
						QC 5 - 50		
						QC 5 - 30		
						QC 5 - 40		
						QC 5 - 61		
						QC 5 - 81		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S264445



Part: D5770-5

Job No: 208152

Serial No/Batch: S264445

Revision: REV.A

Inspector:

Exp Date:

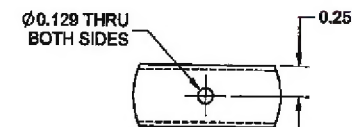
Instructions:

Date: 03/18/20

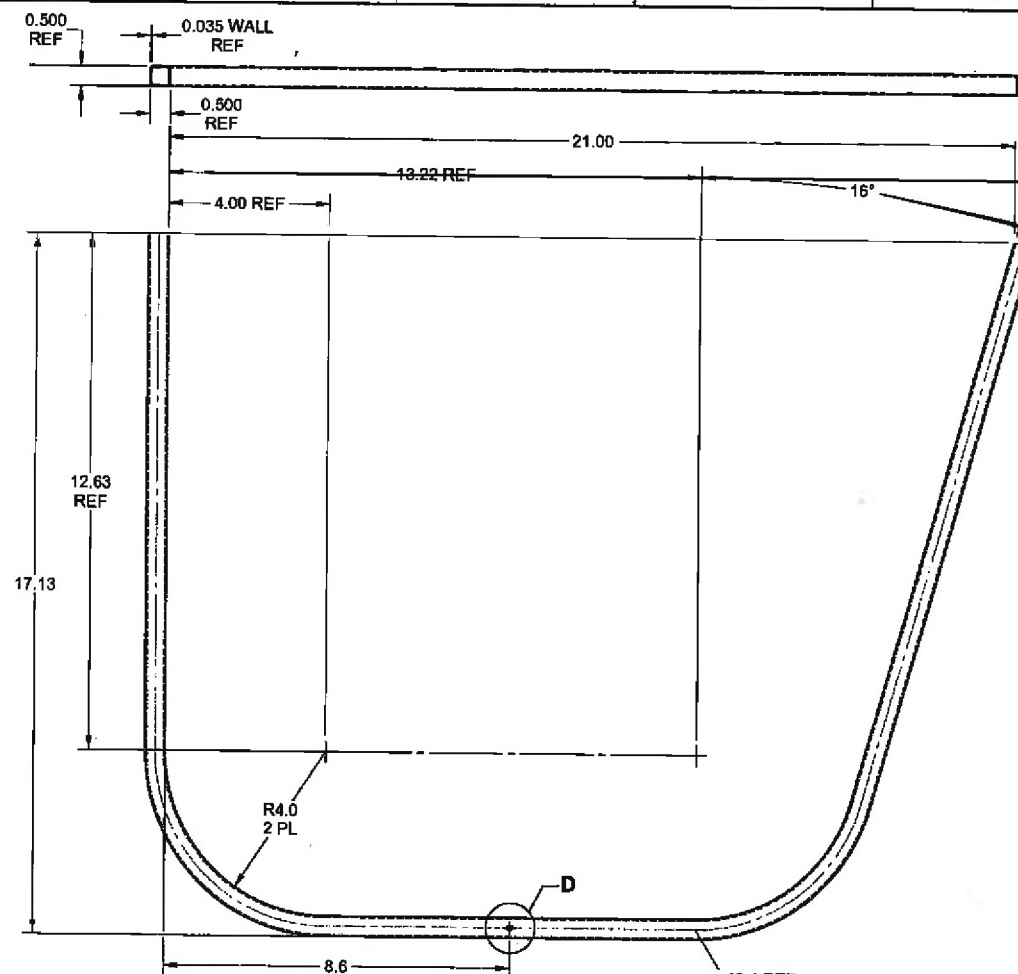
Plex 3/12/20 8:55 AM Dart.Renwick.Jennifer

120 Packaging 3-1 - Stock - B4B 12 pcs	3/23/20	0.00 0.00	Packaging 3 - 1 - B4B	
			Packaging 3 - 2 - B4B	
			Packaging 3 - 3 - B4B	
			Packaging 3 - 4 - B4B	
			Packaging 3 - 5 - B4B	
			Packaging 3 - 6 - B4B	
			Packaging 3 - 7 - B4B	
			Packaging 3 - 8 - B4B	
			Packaging 3 - 9 - B4B	
			Packaging 3 - 10 - B4B	
			Packaging 3 - 11 - B4B	MFL
			Packaging 3 - 12 - B4B	
			Packaging 3 - 13 - B4B	
			Packaging 3 - 14 - B4B	
			Packaging 3 - 15 - B4B	
			Packaging 3 - 16 - B4B	
			Packaging 3 - 17 - B4B	
			Packaging 3 - 18 - B4B	
			Packaging 3 - 19 - B4B	
			Packaging 3 - 20 - B4B	
			Packaging 3 - 21 - B4B	
			Packaging 3 - 22 - B4B	
			Packaging 3 - 23 - B4B	
			Packaging 3 - 24 - B4B	
			Packaging 3 - 25 - B4B	
			Packaging 3 - 26 - B4B	
			Packaging 3 - 27 - B4B	
			Packaging 3 - 28 - B4B	
			Packaging 3 - 29 - B4B	
			Packaging 3 - 30 - B4B	
			Packaging 3 - 31 - B4B	
			Packaging 3 - 32 - B4B	
			Packaging 3 - 33 - B4B	
			Packaging 3 - 34 - B4B	
			Packaging 3 - 35 - B4B	
			Packaging 3 - 36 - B4B	
			Packaging 3 - 37 - B4B	
130 QC 21 - SA 12 pcs	3/23/20	0.00 0.00	QC 21 - SA - 21	125
			QC 21 - SA - 70	25
			QC 21 - SA - 53	15
<p>Part Op 100 - 1- Cut material to 50" 2- Trace line at 12.375" and 27.9375". 3- Bend, first bend at 101 degrees and second bend at 84 degrees. 4- Cut ends to length using DT 106687 5- Remove markings on tube 6- Deburr</p> <p>110 - (QC5- Inspect part completeness to step on W/O)</p> <p>120 - Identify as per dwg & Stock Location: _____ See note 3.</p> <p>130 - QC21- Final Inspection - Work Order Release</p>				
Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M4130NTS0.500W.035	4130 Square Tube .500 X .500 X .035W	49.9920 ft (4.166 ea)	100-Large Fab - Welded Assy-1	5260577
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Welded Assy-1	M4130NTS0.500W.035	50	577	0
Part Specifications				
Specifications could not be found.				

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 208152



DETAIL D
SCALE 3X



D5770-5 HOOP
(DERIVED FROM AERO DESIGN P/N 76421-01)

RELEASED
2020 FEB 18/NO

NOTES:

- 1) MATERIAL: AISI 4130N STEEL SQUARE TUBING, 1/2 X 0.035 WALL
PER MIL-T-6736 OR AMS 6371/6370/6361/6362/6373/6374
REF DART SPEC M4130N-TS0.500W.035
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044
- 7) WEIGHT: 0.85 lbs

UNDER REVIEW

URF 2020-522 20.02.14 (NO)

APPROVED

DESIGN	ZF	DART AEROSPACE LTD	
DRAWN	ZF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	DRAWING NO.	REV. A
MFG. APPR.	DD	D5770	SHEET 6 OF 7
APPROVED	NO	TITLE	SCALE
DE APPR.	CP	BASKET HOOPS	NTS
DATE	20.01.09	COPYRIGHT © 2000 BY DART AEROSPACE LTD	
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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **POHB045883**



Supplier: FAC001-VU
Factory Steel
14020 Oakland Ave.
Detroit, MI 48203 USA
Phone: 313 883 6300
Fax: 313 883 4883

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB045883

PO Date: 2/18/20

Due Date: 2/28/20

Purchase Order

Revision:

Revision Date:

FEB 19 2020

Issued By: Lavoie, Chantal
Phone: 613-623-5200 Ext: 242
Fax: 613-632-1053
clavoie@dartaero.com

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Items													
Line Item	Job	Part	Drawing	Supplier Part No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1		M4130NTS0.500W.035			4130 Square Tube .500 X .500 X .035W : MATERIAL: AISI 4130N STEEL TUBING AS PER MIL-T-6736 OR AMS 6371/6360/6361/6362 6373/6374 receive ft	Firmed -		2/28/20	600 ft	0 ft	600 ft	\$6.49/ft	\$3,894.00
												Grand Total:	\$3,894.00

Order Notes

Procurement Quality Clauses

A005 right of entry

A012 chemical and physical test report

A016 personnel qualification

A017 raw material identification (as applicable). No Raw Metals from China or Soviet Bloc Countries. (DFARS)

A026 certification of material conformance

A041 quality management system

A042 dart notification by supplier

A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program.

A049 supplier awareness.

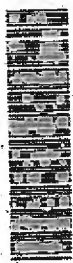
Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 2/19/20 2:52 PM Dart.Lavoie, Chantal

PACKING LIST

No. 67811

PG 1 OF 1



PL

FACTORY STEEL & METAL SUPPLY 14020 OAKLAND AVENUE DETROIT, MI 48203 (313)883-6300 PHONE (313)883-4883 FAX		CUSTOMER PO POHB045883 CUSTOMER JOB		BUYER CHANTEL LAVOIE Tel (613) 632-3336 Fax (613) 632-4443		SHIP DATE 02/21/2020 SHIP VIA *****TRUCK*****			
		SALES ORDER 60752		ORDER DATE 02/19/2020		SALES REP WICK HALON		RESALE # 59-2958719	
SOLD TO DART AEROSPACE 1270 ABERDEEN STREET HAWKESBURY, ON K6A 1K7		SHIP TO DART AEROSPACE 1270 ABERDEEN STREET HAWKESBURY, ON K6A 1K7		SHIP INST CALL WHEN READY PRO#		CARRIER TRUCK BLIND Y/N N			
				TERMS NET 30 DAYS		FOB DETROIT			

LINE	QUANTITY	DESCRIPTION	WIDTH	LENGTH	WEIGHT		
1	611.667 FT	PACK IN CARDBOARD TUBE 4130W CD SMLSS SQ TUBE 1/2" X .035W MILT-6736 Tag Mill Ref # Heat 154506 023914 25537 WTRS (CIRCLE) FAX SHIPMENT INVOICE ALL DATE: INITIAL:		21' / 24' RL	135.361		
			Pcs Length	Feet	Weight		
			27 21' / 24' RL	611.667	135.361		

TOTAL WT 135 LBS		RECEIVED BY - SIGNATURE		RECEIVED BY - PRINTED NAME		DATE RECEIVED	

SO

41021 MATERIAL RECEIPT INSPECTION FORM

MATERIAL: M4130NTSO.520W.035 PO / BATCH NO.: P0410045803
 DATE: MAR 04 2020 5260577

MATERIAL CERT REC'D: YES
 QUANTITY RECEIVED: 611 FT
 QUANTITY INSPECTED: 611 FT
 QUANTITY REJECTED: 0

THICKNESS ORDERED: .500X.520 W.035
 THICKNESS RECEIVED: .500X.520 W.035
 SHEET SIZE ORDERED: —
 SHEET SIZE RECEIVED: —

DESCRIPTION	NCR (Check Y/N)	COMMENTS
SURFACE DAMAGE	Y <input checked="" type="checkbox"/>	
CORRECT FINISH	<input checked="" type="checkbox"/> N	
CORROSION	Y <input checked="" type="checkbox"/>	
CORRECT GRAIN DIRECTION	<input checked="" type="checkbox"/> N	
CORRECT MATERIAL PER M-DRAWING	<input checked="" type="checkbox"/> N	MIL-T-6736
CORRECT THICKNESS	<input checked="" type="checkbox"/> N	
PHOTO REQUIRED	Y <input checked="" type="checkbox"/>	
CORRECT REF # TO LINK CERT	<input checked="" type="checkbox"/> N	HIT 25537
CORRECT MATERIAL IDENTIFICATION	<input checked="" type="checkbox"/> N	
CORRECT M# ON THE MATERIAL	<input checked="" type="checkbox"/> N	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y <input checked="" type="checkbox"/>	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y <input checked="" type="checkbox"/>	

CUT SAMPLE PIECE OF MATERIAL AND PREFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
	HRC	HRB	DUR A	DUR D	WEBSTER
TYPE OF MATERIAL					
SIZE OF TEST SAMPLE					
HARDNESS / DUROMETER READING					

testers located in the Quality Office

QC 15 INSPECTION		ENGINEERING SIGNOFF (if required)	
INSPECTED BY: <u>MAR 04 2020</u>	SIGNED OFF BY: <u>DAS</u>		
DATE: <u>82</u>	DATE: <u>8-23</u>		

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in

LIME1

POMBO45883

M4130NTS0.500W.035



DESIGN DH	DRAWN BY DH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. M4130N-TS	REV. A SHEET 1 OF 1
DATE 05.02.09		TITLE 4130N SQUARE TUBING	SCALE NTS
A	05.02.09	NEW ISSUE	

PURCHASE MATERIAL:

AISI4130N STEEL SQUARE TUBING PER ONE OF
THE FOLLOWING SPEC'S: MIL-T-6736, AMS 6371,
6360, 6361, 6362, 6373 OR 6374

PART NUMBER:

M4130N-TS | A.AAA | W | .TTT |

DAS
92
-39

WHERE A.AAA = WIDTH IN INCHES
TTT = WALL THICKNESS IN INCHES

EXAMPLE: 0.50" X 0.035" WALL = M4130N-TS0.500W.035

RELEASED
05.02.09

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PLYMOUTH TUBE CO.

1208 East 12th Street, Ste. 300, Toledo, OH 43604
Phone: (419) 673-7515 Fax: (419) 672-7340

TRUST YOUR SOURCE - ACCEPT NO SUBSTITUTIONS

PRODUCT CERTIFICATION

SALES ORDER - LINE / RLS

179587 - 1 / C

SHIP TO

Factory Steel & Metal Supply C
14020 Oakland Avenue
Detroit, MI 48203
USA

WORK ORDER 023914

HEAT NUMBER 25537

MELT SOURCE Tamen Steel - Melt/Mfg. USA

PCS/HEAT

0

CUSTOMER P.O.	CUSTOMER PART	QUANTITY	LOADING NO	CERT ID / REV	CERT DATE
3999	SQ-N12035				

PART DESCRIPTION SHSQ0500035J200

**** Square OD ****

Side1: 0.5000 Max:0.5100 Min:0.4900

Side2: 0.5000 Max:0.5100 Min:0.4900

Wall: 0.0350 Max:0.0380 Min:0.0320

Length: 19.00-26.00

Spec: MIL-T 6736B Seamless Aircraft

Grade: 430

Anneal: Cond N

DAS
82
9-89

CERTIFICATION REQUIREMENTS

FAR BAA (FAR 52.225-1 Buy America Act Supplies), DFARS 252.225-7001 By America Act & Bel. of Payments Program FAR TAA (FAR 52.225-5 Trade Agreements) Paragraph 1.1.4.5 This material was produced in accordance with the requirements of ASTM A-459. The Grain size is determined and reported by the raw material supplier in accordance to ASTM E-112. This raw material was magnetic particle inspected by the raw material supplier in accordance to AMS 2640J and/or ASTM E-1444, and rated as Frequency, and Severity to AMS 2301, latest revision. Yield is determined by using the 0.2% offset method. Additional Specifications - AMS-T 6736B, 6360P & 6374L. Material produced in accordance to ASTM A-519-17. Jominy results: J(5/16")=38 J(8/16")=31.

Chemical Analysis

C	Mn	P	S	Si	Al	Cr	Mo	Ni	Pb	Cu	V	Ti	Sn
.30	.56	.008	.005	.29	.025	1.02	.20	.13	.000	.18	.009	.003	.009

Physical Properties

Freq.	Severity	Grain Size
.000	.000	7

Mechanical Properties

TEST	UNITS	TESTS	HIGH	LOW	AVERAGE	STD-DEV
Tensile	Psi	6	121110	115340	118173	2536
Yield	Psi	6	115370	109700	112525	2436
Elongation	%	6	17	17	17	0
Rockwell C	Rc	6	22	22	22	0
TEST	RESULT					
Decarb/OD	Pass					
Total ID/OD decarb	Pass					

I certify that the results are a true and correct copy of the records prepared and maintained by Plymouth Tube Company, Streater in compliance with the requirements of the cited specification. Chemistry is as reported by the Steel supplier. This test report cannot be reproduced or distributed except in full without the written permission of Plymouth Tube.

Janet Derossett
Quality Assurance



PLYMOUTH TUBE CO.

1200 East 12th Street, Streator, Illinois 61364
Phone: (815) 673-1615 Fax: (815) 672-7343

THESE TUBES ARE NOT TO BE SUBSTITUTED



PRODUCT CERTIFICATION

SALES ORDER - LINE / RLS

179687-1 / 0-

SHIP TO

Factory Steel & Metal Supply C
14020 Oakland Avenue
Detroit, MI 48203
USA

WORK ORDER 023914

HEAT NUMBER 25537

MELT SOURCE Tinklen Steel - Melt/Mfg. USA

PCS/HEAT 0

CUSTOMER P.O.	CUSTOMER PART	QUANTITY	LOADING NO	CERT ID / REV	CERT DATE
3999	SQ-N12035				

PART DESCRIPTION
SHSQ0500035J200

Additional Specification(s)

TEST	UNITS	#TESTS	HIGH	LOW	AVERAGE	STD-DEV
Brinell	Brinell	3	251	197	225	27

This test report data is for the heat Chemistry Stated above.

The material in this test report is:

- 1) Drawn in the USA
- 2) Free from Polybrominated Biphenyls (PBB), Polybrominated Diphenyl Ethers (PBDE), and Mercury contamination.
- 3) NAFTA compliant.

End of Certification

DAS
82
9-88

I certify that the results are a true and correct copy of the records prepared and maintained by Plymouth Tube Company, Streator in compliance with the requirements of the cited specification. Chemistry is as reported by the Steel supplier. This test report cannot be reproduced or distributed except in full without the written permission of Plymouth Tube.

Janice Derossett
Quality Assurance

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/>	DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Cross tube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> </div> <div> Eng. (Non-AW) <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Water Jet <input type="checkbox"/> Supplier <input type="checkbox"/> Quality <input type="checkbox"/> </div> </div>		
Date :	Sequence #:	QTY Affected :	MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By
				Lead hand / Supervisor
				QC / QA Coordinator
Root Cause <div style="display: flex; justify-content: space-between;"> <div> Operator <input type="checkbox"/> Manufacturing Process <input type="checkbox"/> Equip/Tooling <input type="checkbox"/> Handling/Presservation <input type="checkbox"/> Material <input type="checkbox"/> Product Improvement <input type="checkbox"/> Process Improvement <input type="checkbox"/> Human Factors <input type="checkbox"/> </div> <div> <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Bending <input type="checkbox"/> Crushing <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Mislabeled </div> <div> <input type="checkbox"/> Contamination <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Incomplete/Unclear Instructions <input type="checkbox"/> Drill Holes <input type="checkbox"/> Fit/Function </div> <div> <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain Direction <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Off-set/Set-up </div> <div> <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Outside Tolerance <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Misread </div> </div>		Other/Details:		